

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012690**Date Inspected:** 19-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

MAGNETIC PARTICLE INSPECTION

ZPMC Notification No: 005380

OBG SEGMENT 6 EAST

This Q.A Inspector performed Magnetic particle Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the OBG segment 6 West. Designation is as follows.

*Solo plate on edge panel.

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 6 EAST

ZPMC Notification No: 005378

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This Q.A Inspector performed Magnetic particle Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the OBG segment 6East. Designation is as follows.

*Utility pipe support clips on deck.

MAGNETIC PARTICLE INSPECTION

ZPMC Notification No: 005385

OBG SEGMENT 7 WEST

This Q.A Inspector performed Magnetic particle Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the OBG segment 7West. Designations are as follows.

DP638-001-009, 010; EP65-001-005, 006; DP646-001-011, 012; SP429-001-017, 018; SP124-001-005~012; BP089-001-013~016; BP035-001-13~016; SP756-001-009~012; SP518-001-013~016; SP437-001-017, 018.

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 7AE-7BE-7CE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048659 performing Shielded Metal Arc Welding process for weld SEG034A-007 located on PCMK weld between bottom panel and side panel (bike path side) in OBG segment 7AE near PP48. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) -FCM-Repair-1. Critical weld repair report identified as B-CWR1211.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066413 performing Shielded Metal Arc Welding process for weld CA033-005 located on PCMK side panel to edge panel (bike path side). ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-TC-U4B-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 069841 performing Shielded Metal Arc Welding process for weld CA036-002 located on PCMK deck panel to edge panel (bike path side). ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054467 performing Shielded Metal Arc Welding process for weld OBE7-003 located on PCMK bottom panel splice weld between OBG segment 7AE and 7BE. ZPMC QC Mr. Zhang Qiang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) -FCM-Repair-1. Critical weld repair report identified as B-WR11143. ZPMC ultrasonic report identified as B787-UT-11763.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037840 performing Shielded Metal Arc Welding process for weld CA033-062 located on PCMK corner assembly. ZPMC QC Mr. Zhang Qiang monitoring this welding. The welding variables recorded by QC appeared to comply with the

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

WPS-345+485-SMAW-3G (3F) Repair.

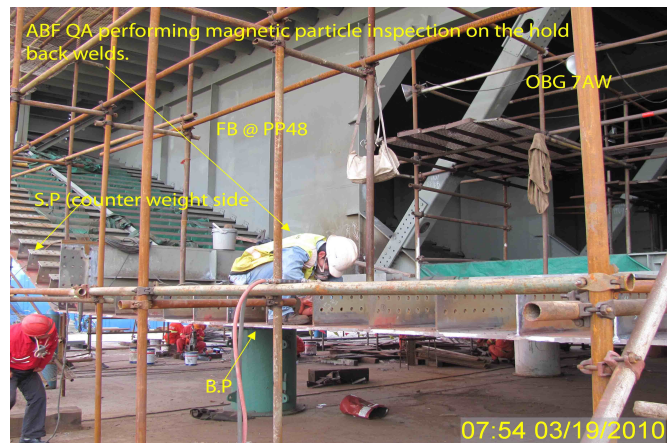
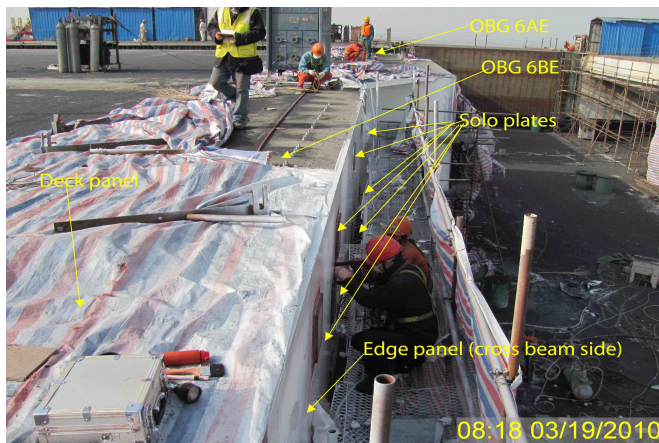
OBG SEGMENT 7CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066422 performing Shielded Metal Arc Welding process for weld CA037-004 located on PCMK weld between edge panel and deck panel (counter weight side) in OBG segment 7CW. ZPMC QC Mr. Tang Ya Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) -FCM-Repair-1. Critical weld repair report identified as B-CWR1228'

OBG SEGMENT 7AW

This Quality Assurance (QA) Inspector observed ABF QA Inspector performing magnetic particle inspection for the hold back weld near the splice weld between OBG segment 7AW and 6CW.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Dawson,Paul

QA Reviewer